

Work Order ID 133737

133737

Tuesday, June 16, 2015 11:05:14 AM

Page 1

Item ID: PB67-43001-79 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lower Blade Support Assembly
 Start Date: 6/16/2015 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 6/16/2015 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: M15 Date: JUN 17 2015 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
B67-43001	C

100 Weld per dwg A/R Aluminum rod Batch: 130855 0.00 6 JUL 20 2015 DAS
 100 Large Fab 24
 Large Fab Memo 0.00 9-89
 Large Fab Weld assembly as per dwg PB67-43001
 USE DT10018

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00 6 15-07-27 DAS
 110 QC Memo 0.00 9
 Quality Control 9-89

120 QC5- Inspect part completeness to step on W/O 0.00 6 15-07-27 DAS
 120 QC Memo 0.00 9
 Quality Control 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																													
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DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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OTHER :																					

Work Order ID 133737

Tuesday, June 16, 2015 11:05:14 AM

133737

Page 3

Item ID: PB67-43001-79

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lower Blade Support Assembly

Start Date: 6/16/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 6/16/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

MLJ

AUG 11 2015

ME

15-8-10

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : ☐																					

Picklist Print

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Page 1

Work Order ID: 133737

133737

Parent Item: PB67-43001-79

PR67-43001-79

Parent Item Name: Lower Blade Support Assembly

Start Date: 6/16/2015

Required Date: 6/16/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-07-17 new issue DD verified by:ec

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PB67-43001-171		Manufactured	No			100	Each	63.0000	6	36			

PR67-43001-171

Mounting Plate

Location Loc Qty Loc Code

Mezz2

63

112996

63

PB67-43001-177

Manufactured No

100

Each

8.0000

1

6

ME 15-7-13

PR67-43001-177

Short Support Plate

Location Loc Qty Loc Code

Mezz2

8

99993

8

PB67-43001-179

Manufactured No

100

Each

8.0000

2

12

ME 15-7-13

PR67-43001-179

Short Side Plate

Location Loc Qty Loc Code

Mezz

8

113404

8

28

ME 15-7-13

~~B134614~~ → 4
B134615 → 4

6102 61 701
JUL 15 2015
DAS
24
9-89

DQA: _____ Date: _____



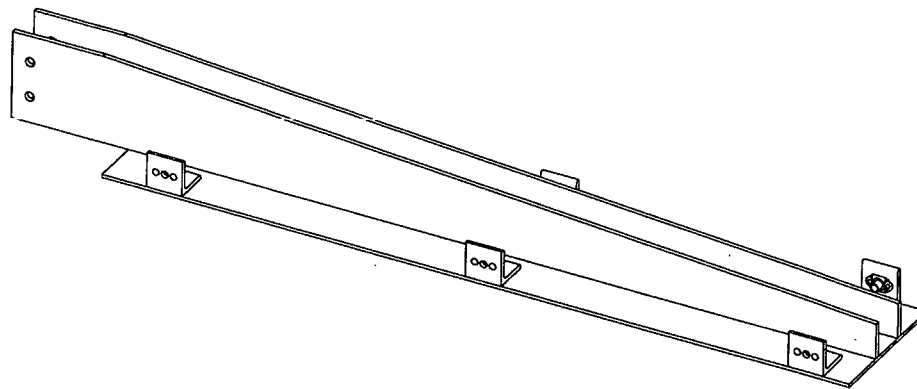
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ITEM	QTY -79	P/N	DESCRIPTION
1	X	B67-43001-79	LOWER BLADE SUPPORT ASSY
3	6	B67-43001-171	MOUNTING PLATE
4	1	B67-43001-177	SHORT SUPPORT PLATE
5	2	B67-43001-179	SHORT SIDE PLATE
7	12	MS20426AD3-4	RIVET
8	6	MS21075L3	NUT PLATE



B67-43001-79 LOWER BLADE SUPPORT ASSY

TOP COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 133733 MLT
15-06-17

RELEASED
R 2009-09-24
MP

NOTES:

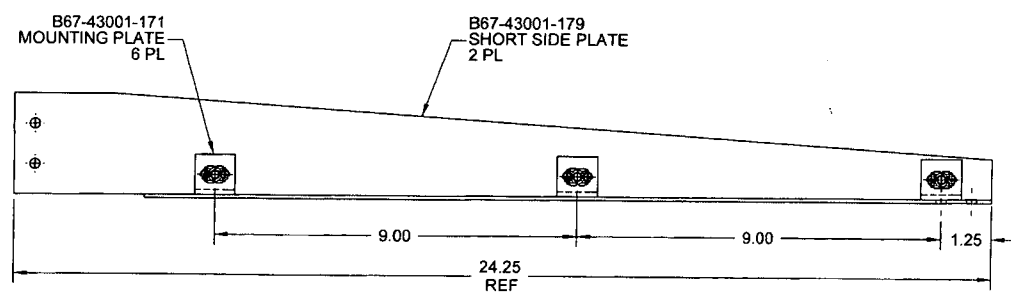
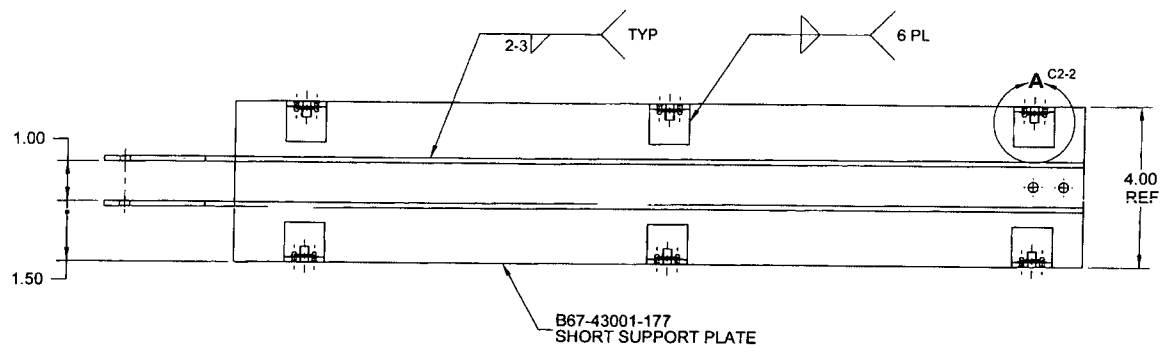
- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREEN SANDEXT" (4.3.5.8) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "B67-43001-79" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.96 lbs
- 8) WELDING: PER DART QSI 004

C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO SHEET 11 OF PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR#09-011.		MB	09.06.26
REV.	DESCRIPTION		BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	JS	DRAWING NO.	REV. C	
CHECKED	JS	B67-43001-79	SHEET 1 OF 2	
MFG. APPR.	JS	TITLE	SCALE	
APPROVED	N/A	LOWER BLADE SUPPORT ASSY	NTS	
DE APPR.	N/A	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		
DATE	09.06.26			

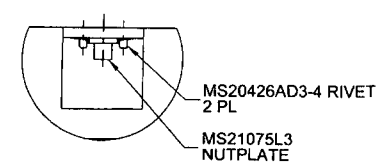
8 7 6 5 4 3 2 1

D
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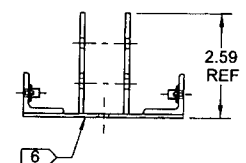
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C
B
A



B67-43001-79 LOWER BLADE SUPPORT ASSY



DETAIL A D4-2
SCALE 2X, 6 PL



RELEASED
2009-09-24
MP

DESIGN	R/W	DART AEROSPACE LTD	
DRAWN	<i>MS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>MS</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>MS</i>	B67-43001-79	SHEET 2 OF 2
APPROVED	<i>MS</i>	TITLE	SCALE
DE APPR.	N/A	LOWER BLADE SUPPORT ASSY	NTS
DATE	09.06.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1